

## Work Order ID 110448

December-20-13 8:37:03 AM

\*110448\*

Page 1

Item ID: D2597

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: 204 Web

Stop \*NS2\*

Start Date: 12/20/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-12-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2597	Rev E
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100

0.00

\*100\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut D2500-3 to length: 84.25"  
Use Jig DT9817 to drill pilot holes.  
Open to 0.625 diameter using a uni-bit.

4 1 13-12-27 DGL

110

0.00

\*110\*

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 13/12/27

(X)

120

0.00

\*120\*

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

4 1 13-12-27 DGL

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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December-20-13 8:37:03 AM

Page 2

**Accept**

**Setup Start**

**\*NS1\***

**Stop**

**\*NS2\***

**Start Date:** 12/20/13      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 1/03/14      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**\*NR2\***

**Insp.  
Stamp**

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

DAS  
19  
9-89  
13.12.30

Identify as per dwg & Stock Location: 46

0.00

**\*140\***

### Packaging

## Memo

0.00

## Packaging

13-12-30  
DGL

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

## Memo

0.00

### Quality Control

MF  
10-12-30

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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# Picklist Print

December-20-13 8:37:08 AM

Page 1  
1

Work Order ID: 110448

**\*110448\***

Parent Item: D2597

**\*D2597\***

Parent Item Name: 204 Web

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D98.10.15Eliminated DEO, Changed Dwg  
RevisionKS  
IPP REV:E ADDED HOLES TO TOOLING 11-09-06 JLM VERIFIED  
BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			110	Each	42.0000	1	4			
<b>*D2500-3-100*</b>										<b>**</b>			

Ext'n -I' Beam Web 4"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	42	
84873	4	
89110	38	

4  
13-12-27 DGL.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

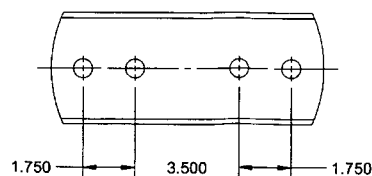
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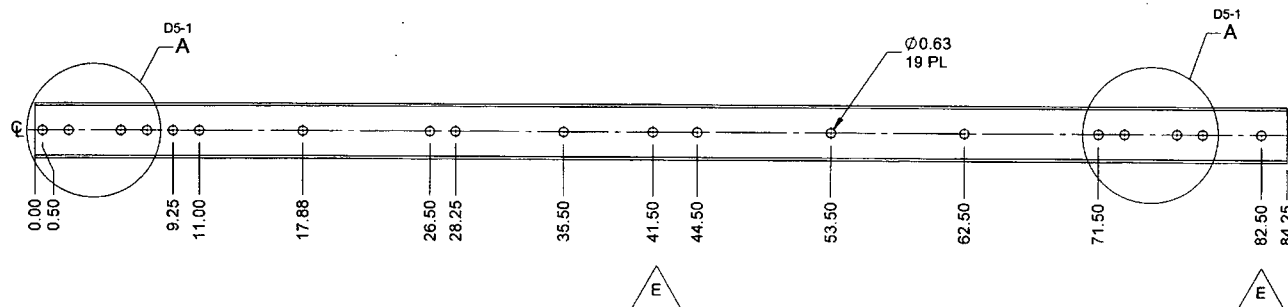
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**DETAIL A**  
SCALE 2X  
C2-1  
C7-1

110448 MJS  
13-12-20



**D2597 WEB (204)**

**RELEASED**  
2011-08-29

**NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D2500-3-84.25 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.99 lbs

REV.	DESCRIPTION	BY	DATE
E	ADD HOLES (ZN B5-1, B2-1)	RF	11.06.21
D	INCORPORATED DEO 9097	CP	98.09.14
C	Ø0.63 WAS Ø0.56	KE	97.07.23
B	5.75 WAS 0.50	DS	96.10.29
A	NEW ISSUE	DS	96.09.16
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MP	DRAWING NO.	REV. E
MFG. APPR.	DS	D2597	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	204 WEB	NTS
DATE	11.06.21	<small> COPYRIGHT © 1996 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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